

Date: Monday, 22/12/2008 3:05:48 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOP PLATE
Job Number :	44242		
Estimate Number :	11211		
P.O. Number :		Part Number :	D33309
This Issue :	22/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3330 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	43509	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	20/01/2009
Written By :		Qty:	4
		Um:	Each
Checked & Approved By :	<u>JLD 08.12.23</u>		
Comment :	Est: A 05.01.13 New issue KJ/JLM est B 07.05.14 rev C dwg EC est rev C 07.12.12 revD dwg EC verified by:DD est rev D 08.12.16 waterjet EC verified by: DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010B0375X03500

1010-1025 Steel Bar .375 x 3.500



Comment: Qty.: 0.2888 f(s)/Unit Total : 1.1550 f(s)

1010-1025 Steel Bar

Fabricate Top Plate as per Dwg D3330

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 0.375" x 3.500" Ba

(M1010-B0.375x03.500)

Identify as D3330-9

Batch: 106317

LB 9-1-13

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3330

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

LB 9-1-13

4

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 9-1-13

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

509/6113 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:05:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PLATE

Job Number: 44242

Part Number: D33309

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl Weld Booth

JS 09/01/14 (H)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15 (H)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JUD 09/01/14 (H)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

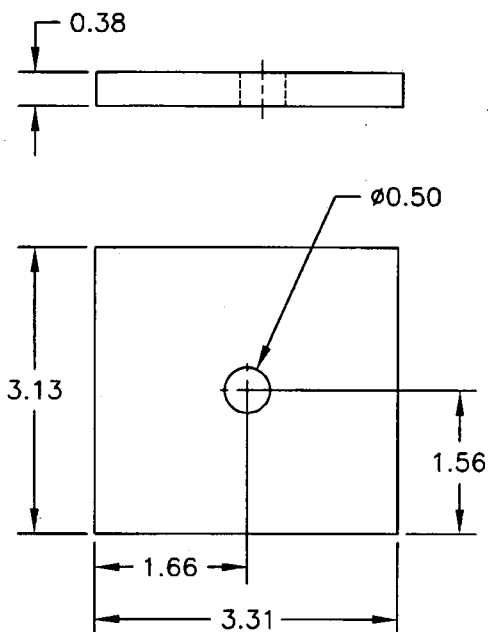
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

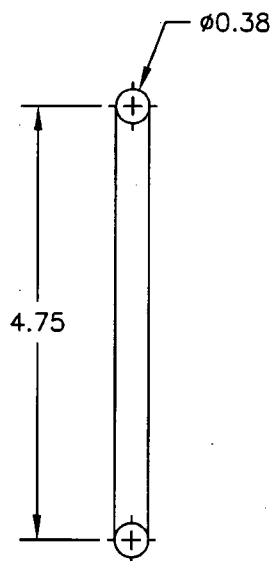


DESIGN <i>[Signature]</i>	DRAWN BY <i>DCP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 7 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

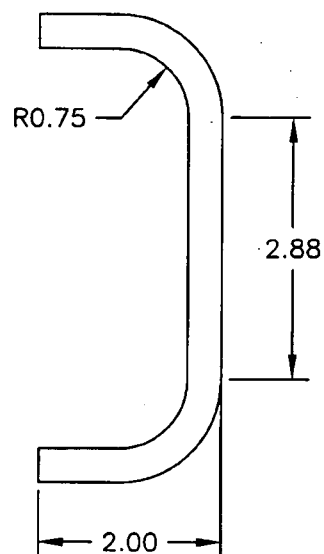
RELEASED
07.12.07 *[Signature]*



1 D3330-9 TOP PLATE



2 D3330-15 HANDLE



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44242*

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